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D3340-13
Job Sheet 191137



Part No: D3340-13

Job Qty: 4 pcs

Part Name: Skidtube Protector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Created By: Linda Lacelle

Due Date: 2/25/19

Description:

Type: SOLD

Note: DWG REV B IPP: A 05.11.10 Preliminary issue AP/EC IPP Rev:B Now on Waterjet 06-10-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		2/25/19	0.00	0.75	Waterjet - Flow		du 19/02/21
110	QC 2	4 pcs		2/25/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		du 19/02/21
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

120	QC 8	4 pcs	2/25/19	0.00 0.00	QC 2 - 66	
					QC 2 - 64	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	DAS FEB 21 2019 68
					QC 8 - 67	9-89
					QC 8 - 47	
130	Small Fab - Brake NC - B4B	4 pcs	2/25/19	0.00 0.24	Small Fab - Brake - 1 - B4B	DAS 19/02/26
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
140	QC 5	4 pcs	2/25/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS 40 9-89
					QC 5 - 9	DAS 9-89
					QC 5 - 50	DAS 9-89
					QC 5 - 30	
150	Powdercoat - 3 Grey Sand - B4B	4 pcs	2/25/19	0.00 0.17	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BL 19-02-27.
					Powdercoat - 4 - B4B	
160	QC 3	4 pcs	2/25/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	

				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	DAS
				QC 3 - 68	FEB 27 2019 8
				QC 3 - 9	9-89
170	Packaging 3-1 - Stock - B4B	4 pcs	2/25/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
180	QC 21 - SA	4 pcs	2/25/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - 1-Cut as per Dwg D3340 Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - (Bend/Assemble as per dwg), Deburr if necessary Form on brake as per Dwg D3340 using Jigs DT 8326 and DT8261 140 - QC5- Inspect part completeness to step on W/O <i>M 138370</i> 150 - (Grey Sandtex(Ref 4.3.5.6) per QSI005 4.3), START TIME: <i>12:35</i> OVEN TEMPERATURE: <i>300</i> FINISH TIME: <i>11:05</i> 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M1010S20GA	1010/1025 Sheet	5.0400 sf (1.26 ea)	100-Waterjet - Flow - 1	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M1010S20GA	5	85	0
Part Specifications				
Specifications could not be found.				

Plex 2/21/19 2:23 PM dart.lacelle.linda

DART AEROSPACE LTD		Work Order:	19437
Description: Aft Skidtube Protector		Part Number:	D3340-13
Inspection Dwg: D3340 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.254	1			
0.300	+/-0.010	.299	1			
0.50	+/-0.030	.50	1			
0.250	+/-0.010	.252	1			
2.315	+/-0.010	2.314	1			
2.815	+/-0.010	2.817	1			
1.625	+/-0.010	1.624	1			
23.125	+/-0.010	23.125	1			
26.625	+/-0.010	26.625	1			
52.315	+/-0.010	52.315	1			
55.815	+/-0.010	55.815	1			
58.190	+/-0.010	58.190	1			
61.000	+/-0.010	61.000	1			
63.565	+/-0.010	63.565	1			
0.040	+/-0.010	.037	1			

Measured by:	AC	Audited by:	DAS 62	Preliminary Approval:	
Date:	19/02/21	Date:	9-23	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	






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CANADA
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Container No: S155583



Part: D3340-13

Job No: 191137

Serial No/Batch: S155583

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/21/19